



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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DSK081

Job Sheet 184876



Part No: DSK081

Job Qty: 7 ea

DAS
21
9-89

Part Name: D2940-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	7 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-4		
100	Doosan	7 pcs	11/9/18	11/9/18	0.20	7.95	Doosan		
110	QC	7 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		
120	QC	7 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		
130	Packaging	7 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-2		
140	QC21-SA	7 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 100 - Turn blank as per Folio FA079
Descriptions: 130 - LOCATION: MAT060

DAS
21
9-89

NOV 06 2018
NOV 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-007	Round Billet, 17-4	7 Ea (1 ea)	90-Start up Operation	

5062575
5083250
5079948

4
5
6

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-007	7	26	0

Part Specifications

Specifications could not be found.

Plex 10/17/18 12:43 PM Dart.lajeunesse.marie

9h30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER : ☐							

DART AEROSPACE LTD		Work Order:	184876
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.213				3.2125
B	4.946	4.966		4.953				4.955
C	0.718	0.738		.728				.729
D	0.090	0.110		.099				.099
E	3.564	3.584		3.574				3.5745
F	0.022	0.042		.032				Rxn
G	3.444	3.464		3.454				3.4535
H	0.112	0.132		.120				.1215
I	2.170	2.190		2.184				2.1795
J	4.451	4.471		4.463				4.463
K	0.413	0.433		.426				.424
L	0.913	0.933		.925				.926
M								
N								
O								
P								

Measured by: *[Signature]* **Date:** 18/11/06

Audited by: *[Signature]* **Date:** 18/11/06

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

DART AEROSPACE LTD		Work Order: 184876
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216	bore-gage	3.215	3.211	3.213	3.2125	3.213
B	4.946	4.966		4.957	4.959	4.953	4.953	4.953
C	0.718	0.738		.7195	.72	.728	.728	.728
D	0.090	0.110		.092	.0915	.098	.098	.097
E	3.564	3.584		3.574	3.575		3.574	3.575
F	0.022	0.042		R.132				
G	3.444	3.464	3.45	3.453	3.4525		3.454	3.453
H	0.112	0.132		.122	.122		.120	.120
I	2.170	2.190		2.178	2.177		2.178	2.1755
J	4.451	4.471		4.462			4.461	4.461
K	0.413	0.433		.424			.422	.422
L	0.913	0.933		.928			.920	.920
M								
N								
O								
P								

Measured by: P. B. H. 05 Date:

Audited by: mm Date: 14/11/06

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Hewlett-Packard, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/06/18

DART
AEROSPACE

Container No: S124823



Part: DSK081

Job No: 184876

Serial No/Batch: S124823

Revision:

Inspector:

Exp Date:

Instructions:

MULT CATEGORY

t /Unqualified	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
e/Unclear	☐	Fit/Function	☐	Misread
	☐	Misaligned/off center	☐	Turning Sequence